



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Reprint
D206-642-311BL
Job Sheet 166714-A



Part No: D206-642-311BL

Job Qty: 1 ea

Part Name: Skidtube LH (Ael Blue)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 11/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Air Evac Lifetech (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O (*AEL*), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: DWG REV Q SHEETS 29-30 IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M as per REV.N DD 10.04.19 verified by:EC IPP Rev:N 14.04.25 ECN14-520 DD verf.JLM IPP REV:O 15.10.09 ADDED BL DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/27/17	0.00	0.00	Start Up Stores/Pkg-1		
100	DC	1 pcs		11/27/17	0.00	0.00	DC		
110	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging1		
120	QC	1 pcs		11/27/17	0.00	0.00	QC4		
130	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		11/27/17	0.00	0.00	QC21		

Part Op 100 - Document Control Photocopy bluefile and create labels per PPP D206-642-311 CHG008

Descriptions: 110 - Pick Kit

120 - QC4- 100% Inspect kits for completeness

130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-311 Location:

PPP Rev: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	AN3-41A <i>501371</i>	8 ✓	33	0	0
	AN4-6A <i>501371</i>	12 ✓	449	0	0
	AN4C5A <i>501371</i>	1 ✓	31	0	0
	AN5-10A <i>501371</i>	4 ✓	155	0	0
	AN5-11A <i>501371</i>	8 ✓	440	0	0
	AN5-12A <i>501371</i>	4 ✓	496	0	0
	D206-642-341BL <i>501333</i>	1 ✓	19	0	0
	D206-648-013BL <i>501371</i>	1 ✓	2	0	0
	D2652 <i>501371</i>	16 ✓	340	0	0
	D2712 <i>501371</i>	10 ✓	93	0	0
	D2932-1BL <i>501371</i>	1 ✓	1	0	0
	D2933-1BL <i>501423</i>	1 ✓	1	0	0
	D2934 <i>501371</i>	2 ✓	28	0	0
	D2935 <i>501371</i>	2 ✓	48	0	0
	D2938-1BL <i>501445</i>	1 ✓	1	0	0
	D2939-1BL <i>501423</i>	1 ✓	1	0	0
	<i>5008458</i>				
	<i>5015435</i>				
	<i>5015435</i>				

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

AGAINST DEPARTMENT/PROCESS Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐		MRB (QS1042) Approval	
Completed By		Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval		Positioned Wrong	
Power Loss/ Surge		Outside Dimensions	
Folio/Program		Over/Under tolerance	
Grain		Part Incorrect	
Weld		Part Lost/Missing	
Wrong Stock Pulled		Part Moved	
Out of Sequence		Drawing	
Off-set		Finish	
Mislabeled		Misread	
Fit/Function		Turning Sequence	
Misaligned/off center			

DART AEROSPACE

S015752



Skidtube LH (Ael Blue)

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:		D206 - 642 - 311BL	
Revision:		Start up Operation	
Operation:		Mfg Date: 11/30/17	
Change No:		Job No: 166714 - A	

Work Order: _____		Suspect	
Part No. _____		Step #:	
NCR No. _____		Description Work Order Deviation	
Date: _____		Drill Holes	

Root Cause		OTHER :	
Environment	No Re-verification	Pres	
Design	Operator	Ben	
Doc/Data	Offset/Setup	Cer	
Equip/Tooling	Supplier	Cra	
Handling/Pre	Training	Cri	
Material	Use for Testing	Cu	
Internal Transport	Poor Information	Cr	
Tribal Knowledge	Rushing	H	
LOA	Product Improvement	Wave/Twist in raw	
Substation	Process Improvement	Marks/Chatter	
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		

	- D3407-043	5013701	1 ✓	29	0	0
	D3413-1	5014236	1 ✓	47	0	0
	- D3456-1	5013700	1 ✓	69	0	0
5015607	D3457-1	5013700	2	14	0	0
	- MS21042L3	5013699	8 ✓	1,029	0	0
	MS21042L4		12	1,019	0	0
	- MS21043-4	5013698	1 ✓	813	0	0
5014228	- NAS1149C0463R	5013698	1 ✓	119	0	0
	- NAS1149D0363J	5013696	8 ✓	247	0	0
5014970	- NAS1149D0463J		24 ✓	527	0	0
	- NAS1149D0563J	5013695	8 ✓	1,238	0	0

Part Specifications

Specifications could not be found.

Plex 11/20/17 3:27 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

DART AEROSPACE USA, INC.

IIN-D206-642

Page 29 of 43

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1				X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	*INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

* COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. *

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: Q

Date: 13.08.12